

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73682

Tuesday, September 13, 2011 10:19:16 AM



Page 2

Item ID: D2573	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Saddle, Aft Out 205					
Start Date: 9/13/2011	Start Qty: 12.00		Cust Item ID:		
Required Date: 9/30/2011	Req'd Qty: 12.00		Customer:		
Reference:					

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run	Start	
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		11/4/14		12			
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							12xφ m-f 11/4/14
150 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo	0.00 0.00							12xφ m-f 11/4/14

START TIME: 12:00
FINISH TIME: 12:30
OVEN TEMPERATURE: 3200 F

m 118439

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73682

Tuesday, September 13, 2011 10:19:16 AM



Page 3

Item ID: D2573

Accept



Setup Start



Revision ID:

Item Name: Saddle, Aft Out 205

Stop



Start Date: 9/13/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 9/30/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

12 Bk 11-11-14.

170

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

Packaging 12

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/11/14 JMF 11-11-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, September 13, 2011 10:20:09 AM

Page 1

Work Order ID: 73682



Parent Item: D2573

Parent Item Name: Saddle, Aft Out 205

Start Date: 9/13/2011

Required Date: 9/30/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: 1 As Per RevE 06-01-27 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6101-007

Manufactured

No

100

Each

41.0000

1

12



Saddle Billet

Location

Loc Qty

Loc Code

MAT

8

71722

8

MAT042

22

72228

2

→ 73421

20

MAT045

11

65383

1

65954

4

70680

6

12

only 11/11/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: <i>73602</i>
Description: Saddle, Aft Outboard	Part Number: D2573
Inspection Dwg: D2573 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		0.440	0.440	0.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.002	8.002	8.002	8.001		
F	0.490	0.510		0.502	0.501	0.501	.500		
G	0.257	0.262		0.259	0.259	0.259	.259		
H	0.375	0.380		0.377	0.377	0.377	.377		
I	0.490	0.510		0.501	0.501	0.501	.501		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.569	0.569	0.569	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		0.125	0.125	0.125	.125		
Q	0.115	0.135		0.135	0.135	0.135	.135		
R	0.240	0.260		0.250	0.250	0.250	.248		
S	0.115	0.135		0.130	0.130	0.130	.130		
T	0.178	0.198		0.188	0.188	0.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.240	0.240	0.238	.234		
W	0.115	0.135		0.128	0.124	0.124	.124		
X	0.308	0.313		0.3095	0.3095	0.3095	.309		
Y	0.760	0.765		0.763	0.763	0.763	.764		
Z	0.352	0.372		0.363	0.362	0.362	.359		
AA	0.470	0.530		0.500	0.500	0.500	.500		
AB	0.615	0.635		0.620	0.620	0.620	.619		
AC	0.053	0.073		0.063	0.063	0.063	.063		
AD	0.240	0.260		0.248	0.247	0.247	.245		
AE	1.500	1.520		1.5132	1.5137	1.5135	1.5125		
AF	0.115	0.135		0.135	0.135	0.135	.130		
AG	0.240	0.280		0.275	0.275	0.275	.275		
AH	0.240	0.260		0.252	0.247	0.247	.244		
AI	2.000	2.020		2.0006	2.007	2.002	2.002		
AJ	0.023	0.043		0.033	0.033	0.033	.033		
Accept/Reject									

Measured by: <i>B.A.</i>
Date: <i>11/11/10</i>

Audited by: <i>[Signature]</i>
Date: <i>11/11/10</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: <i>73602</i>	
Description: Saddle, Aft Outboard		Part Number: D2573	
Inspection Dwg: D2573 Rev. E		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	<i>15</i>	<i>16</i>	<i>17</i>	<i>18</i>	By	Date
A	0.438	0.443		<i>.440</i>	<i>.440</i>	<i>.440</i>	<i>.446</i>		
B	1.745	1.755		<i>1.750</i>	<i>1.750</i>	<i>1.750</i>	<i>1.750</i>		
C	3.495	3.505		<i>3.500</i>	<i>3.500</i>	<i>3.500</i>	<i>3.500</i>		
D	1.745	1.755		<i>1.750</i>	<i>1.750</i>	<i>1.750</i>	<i>1.750</i>		
E	7.990	8.010		<i>8.001</i>	<i>8.001</i>	<i>8.001</i>	<i>8.001</i>		
F	0.490	0.510		<i>.501</i>	<i>.500</i>	<i>.502</i>			
G	0.257	0.262		<i>.259</i>	<i>.259</i>	<i>.259</i>	<i>.259</i>		
H	0.375	0.380		<i>.377</i>	<i>.377</i>	<i>.377</i>	<i>.377</i>		
I	0.490	0.510		<i>.501</i>	<i>.500</i>	<i>.500</i>	<i>.500</i>		
J	1.174	1.184		<i>1.179</i>	<i>1.179</i>	<i>1.179</i>	<i>1.179</i>		
K	0.558	0.578		<i>.569</i>	<i>.568</i>	<i>.568</i>	<i>.568</i>		
L	1.174	1.184		<i>1.179</i>	<i>1.179</i>	<i>1.179</i>	<i>1.179</i>		
M	1.365	1.375		<i>1.370</i>	<i>1.370</i>	<i>1.370</i>	<i>1.370</i>		
N	2.495	2.505		<i>2.500</i>	<i>2.500</i>	<i>2.500</i>	<i>2.500</i>		
O	4.119	4.129		<i>4.124</i>	<i>4.124</i>	<i>4.124</i>	<i>4.124</i>		
P	0.115	0.135		<i>.125</i>	<i>.125</i>	<i>.125</i>	<i>.125</i>		
Q	0.115	0.135		<i>.135</i>	<i>.135</i>	<i>.135</i>	<i>.135</i>		
R	0.240	0.260		<i>.247</i>	<i>.248</i>	<i>.249</i>	<i>.248</i>		
S	0.115	0.135		<i>.129</i>	<i>.130</i>	<i>.128</i>	<i>.129</i>		
T	0.178	0.198		<i>.188</i>	<i>.188</i>	<i>.188</i>	<i>.188</i>		
U	3.210	3.250		<i>3.230</i>	<i>3.230</i>	<i>3.230</i>	<i>3.230</i>		
V	0.230	0.250		<i>.236</i>	<i>.236</i>	<i>.235</i>	<i>.236</i>		
W	0.115	0.135		<i>.129</i>	<i>.131</i>	<i>.128</i>	<i>.128</i>		
X	0.308	0.313		<i>.308</i>	<i>.310</i>	<i>.309</i>	<i>.309</i>		
Y	0.760	0.765		<i>.764</i>	<i>.764</i>	<i>.764</i>	<i>.764</i>		
Z	0.352	0.372		<i>.360</i>	<i>.361</i>	<i>.360</i>	<i>.360</i>		
AA	0.470	0.530		<i>.500</i>	<i>.500</i>	<i>.500</i>	<i>.500</i>		
AB	0.615	0.635		<i>.619</i>	<i>.619</i>	<i>.620</i>	<i>.619</i>		
AC	0.053	0.073		<i>.063</i>	<i>.063</i>	<i>.063</i>	<i>.063</i>		
AD	0.240	0.260		<i>.247</i>	<i>.246</i>	<i>.246</i>	<i>.246</i>		
AE	1.500	1.520		<i>1.5125</i>	<i>1.5115</i>	<i>1.5134</i>	<i>1.513</i>		
AF	0.115	0.135		<i>.130</i>	<i>.130</i>	<i>.130</i>	<i>.130</i>		
AG	0.240	0.280		<i>.275</i>	<i>.275</i>	<i>.275</i>	<i>.275</i>		
AH	0.240	0.260		<i>.245</i>	<i>.246</i>	<i>.245</i>	<i>.246</i>		
AI	2.000	2.020		<i>2.002</i>	<i>2.002</i>	<i>2.003</i>	<i>2.003</i>		
AJ	0.023	0.043		<i>.033</i>	<i>.033</i>	<i>.033</i>	<i>.033</i>		
Accept/Reject									

Measured by:	<i>cmf</i>
Date:	<i>11/11/12</i>

Audited by:	<i>SA</i>
Date:	<i>11/11/12</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>SA</i>

DART AEROSPACE LTD	Work Order: 73602
Description: Saddle, Aft Outboard	Part Number: D2573
Inspection Dwg: D2573 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

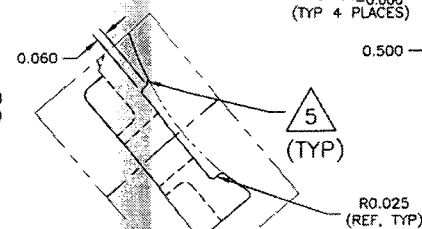
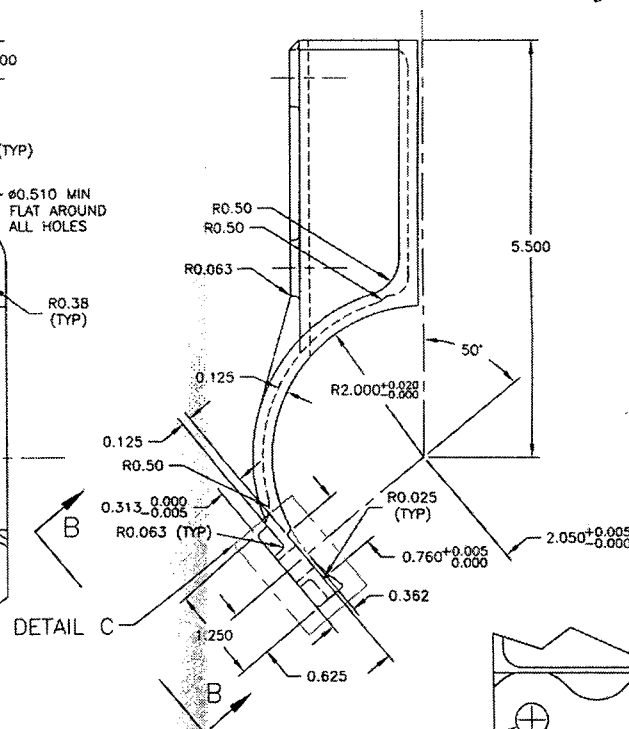
				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	X9	210	211	412		
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.001	8.001	8.001		
F	0.490	0.510		.501	.501	.501	.501		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.501	.501	.502	.501		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.568	.569	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.125	.125	.125	.126		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.248	.248	.247	.250		
S	0.115	0.135		.128	.128	.128	.131		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.236	.236	.237	.238		
W	0.115	0.135		.129	.128	.130	.130		
X	0.308	0.313		.309	.309	.309	.310		
Y	0.760	0.765		.764	.764	.764	.764		
Z	0.352	0.372		.360	.360	.360	.360		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.619	.619	.619	.619		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.246	.245	.246	.245		
AE	1.500	1.520		1.512	1.5125	1.512	1.5125		
AF	0.115	0.135		.130	.130	.130	.130		
AG	0.240	0.280		.280	.280	.280	.280		
AH	0.240	0.260		.246	.246	.247	.247		
AI	2.000	2.020		2.002	2.003	2.002	2.0033		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	am
Date:	11/11/12

Audited by:	S
Date:	11/11/14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED
05.12.06 #

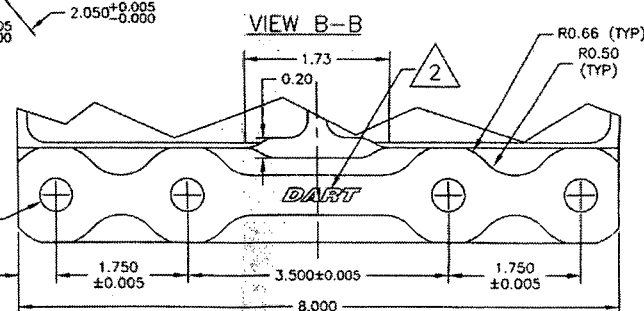


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DART AEROSPACE LTD.

MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-001)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125
- 3 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.063" x 45° ALL AROUND
- 5 CHAMFER 0.033" x 45° (SEE DETAIL C)



REV. 1
OF
SCALE
2-

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries